Date: Monday, 24/11/2008 9:16:17 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	**Drawing Name**	: D2894-1 REWORK
Job Number	: 43713		
Estimate Number	: 10804		
P.O. Number	:	**Part Number**	: D28941
This Issue	: 24/11/2008 S.O. No. :	**Drawing Number**	: ECN 08-561
Prsht Rev.	: NC	**Project Number**	:
First Issue	: / / **Type** : MACHINED PARTS	**Drawing Revision**	:
Previous Run	: 00015	**Material**	:
Written By	:	**Due Date**	: 01/12/2008 **Qty:** 18 **Um:** Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

PULL FROM STOCK:

18 X D2894-1   B35578   , B21475

REWORK PER ECN 08-561 &
PER DRWG D2894-1 REV.D
         J.L   08/11/26

Seq. #:	Machine Or Operation:	Description :
2.0	D28941	2.750 Support

Comment: Qty.:   1.0000 Each(s)/Unit   Total :   18.0000 Each(s)
2.750 Support
         mf   08.11.27

Seq. #:	Machine Or Operation:	Description :
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE
         J.L   08/11/26

Seq. #:	Machine Or Operation:	Description :
4.0	QC8	SECOND CHECK

Comment: SECOND CHECK
         08.11.26

Seq. #:	Machine Or Operation:	Description :
5.0	POWDER COATING	POWDER COATING

M109152   (213X)

Comment: POWDER COATING

REPAINT REWORKED ARE   mf   08/11/27

+ 3 (see W/O 43704)

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D2894-1 REWORK

Job Number: 43713

Part Number: D28941

Job Number:	IIIIIIIIIIIIIIIIIIIIII

Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 08 11 27 &23;

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

RETURN TO STOCK
USING NEW B/N

ml 08 11 27 &23;

8.0	QC21	FINAL INSPECTION/W/O RELEASE

08/11/28

Comment: FINAL INSPECTION/W/O RELEASE

mF 08-11-27

Job Completion IIIIIIIIIIIIIIIIIIIIIIIIIII
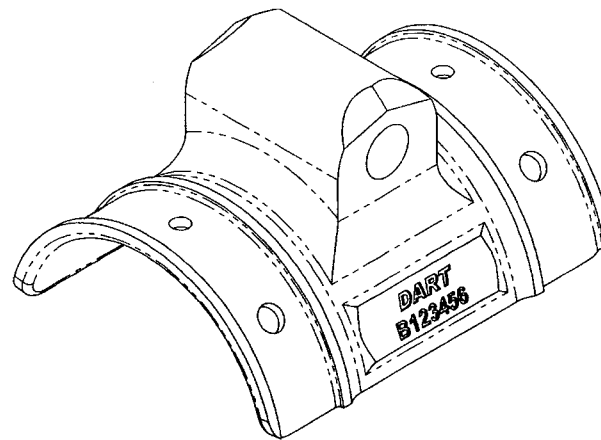
D2894-1 Ø2.750 SUPPORT

RELEASED

NOTES:
1) MATERIAL: 17-4 PH STAINLESS STEEL
        HEAT TREAT TO H900 CONDITION
        (900°F FOR 1 HR, AIR COOL)
        MIN UTS = 170 KSI (38 HRc)
2) FINISH: PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2 /D\
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,
    WITH R0.25 RADIUS OF TRANSITION IN THIS AREA
    IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE
    SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE
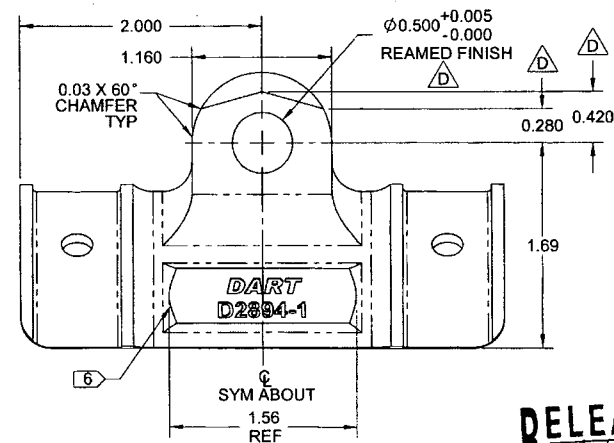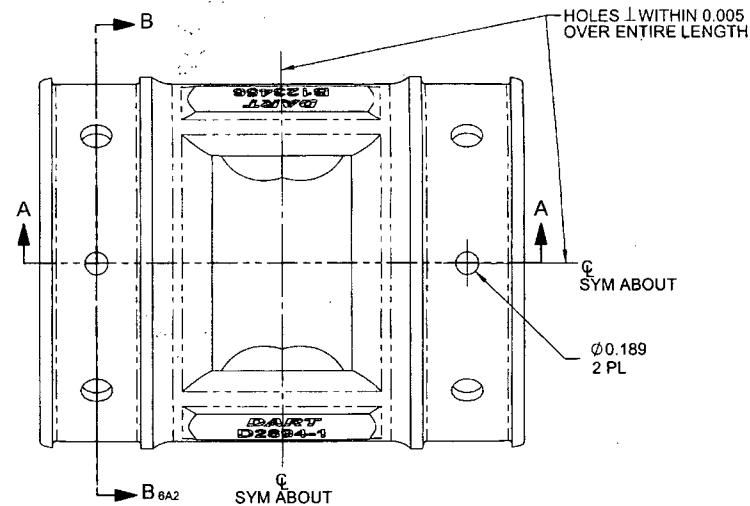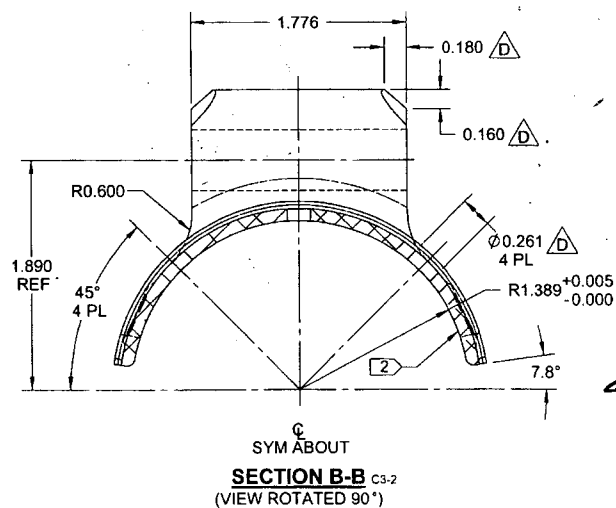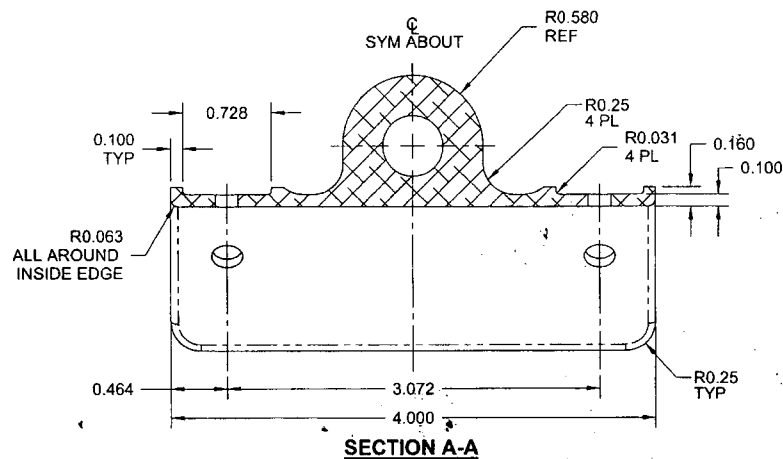   SIDE USING 0.010-0.020 DEEP LETTERING
7) WEIGHT: 0.98 lbs

	DRAWING REFORMATTED. POWDER COAT FINISH REMOVED. CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM, PER BELL TECH BULLETIN 407-08-84. B5-2 0.261 HOLE WAS 0.257. B2-2 REAM FINISH INSTRUCTION ADDED.		
D		AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
REV.	DESCRIPTION	BY	DATE

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2894	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		Ø2.750 SUPPORT	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DART
B123456

SECTION A-A

Callouts on Section A-A:
- R0.580 REF
- SYM ABOUT
- R0.25 4 PL
- R0.031 4 PL
- 0.160
- 0.100
- 0.728
- 0.100 TYP
- R0.063 ALL AROUND INSIDE EDGE
- 0.464
- 3.072
- 4.000
- R0.25 TYP

SECTION B-B C3-2
(VIEW ROTATED 90°)

Callouts on Section B-B:
- 1.776
- 0.180 /D\
- 0.160 /D\
- R0.600
- Ø0.261 /D\ 4 PL
- 1.890 REF
- 45° 4 PL
- R1.389 +0.005 -0.000
- 2 (flag)
- 7.8°
- SYM ABOUT

Callouts on right-hand views:
- B
- HOLES ⊥ WITHIN 0.005 OVER ENTIRE LENGTH
- A / A
- SYM ABOUT
- Ø0.189 2 PL
- B 6A2
- SYM ABOUT
- 2.000
- 1.160
- Ø0.500 +0.005 -0.000 REAMED FINISH
- /D\ /D\
- 0.03 X 60° CHAMFER TYP
- 0.280 0.420
- 1.69
- 6 (flag)
- DART D2894-1
- SYM ABOUT
- 1.56 REF

D2894-1 Ø2.750 SUPPORT

wo 43713

RELEASED
08/11/19

DESIGN	DS	**DART AEROSPACE LTD**	
DRAWN	A.S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2894	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		Ø2.750 SUPPORT	NTS
DATE	08.11.06		

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

Date:	08.11.19	Job No.:	00569	ADR Yes/No:	Y	ADR Date:	08.11.07	ECN #:	08- 561
Product No.:	D407-667-205			Created By:		Approved By:			
Product Name:	CROSSTUBE			Checked By:		General Manager Approval:			

Distribution	Reqd	Resp	Initial / Date	Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL		DQA / QA Coord	N		
Production Engineering Coord	Y	JLM		QC Coordinator	N		
Production Document Control	N			Marketing	N		
Customer Technical Support	N			Customer Order Processing	N		

Reason for Change:	BELL REDESIGN OF AIRCRAFT ROCKER BEEM SEE ADR DATED 08-11.07 FOR FURTHER DETAILS

Documents Affected:

D2894 REV D

PARTS MUST COMPLY [X]   **PREVIOUS PARTS SATISFACTORY** [ ]

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		08.11.20
9	Update Blue/Pink/DSI Folder and Electronic Files	N			
10	Update Controlled PDF Files	Y	KJ		08.11.20
11	Update Master Document List (MDL)	Y	AJS		08.1.20
12	Update Document Record (DR)	Y	KJ	Rev. M	08.11.20
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	N			
18	Create / Update PPP's	N			
19	Update Document Control Database / Laminated Dwgs	Y	KJ		
20	Update Grey Project Binder	Y	AJS		CCS 1/20/SS
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		08.11.20
22					
23					

REFERENCE ONLY

Description / Action:

RELEASE D2894 REV D

ALL PARTS IN HAWKESBURY STOCK MUST COMPLY, REWORK EXISTING STOCK.

w/o   43704

ECN Verified & Complete: _____   Date: _____